

Date: Monday, 02/03/2009 11:23:56 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR
Job Number : 46173	
Estimate Number : 10766	
P.O. Number :	Part Number : D32453
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D3245 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 42487	Material :
Written By :	Due Date : 20/03/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.03.02</u>	
Comment : Est. A 04.07.07 New issue KJ/JLM	
Est Rev:B Now on Waterjet 07-09-14 JLM Verified By:EC	
Est Rev:c ECN 1052 07-10-31 DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.5639 sf(s)/Unit Total : 2.2554 sf(s)

304/316 .032 Sheet

BATCH: 109057 B9-3-B

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3245

Dwg Rev: BProg Rev: BB9-3-B(5)

2-Deburr if necessary

B9-3-B

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B9-3-B**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKS 09/03/16 (85)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Deburr if necessary, buff entire surface to ensure a nice surface finish.

Form D3245-3 as per Dwg D3245

Identify as D3245-3

SB 09/03/23 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:23:56 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 46173

Part Number: D32453

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 02/03/23 (S)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF 233A

AS 09/03/24 (15)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 (15)

Job Completion



mf 09-03-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3245-5 DOOR

2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)

D3245-7 GASKET
(REF)

8.00
(TYP, REF)

D3245-043 DOOR ASSEMBLY

INSTALL D3245-7
GASKET ON THIS SIDE

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

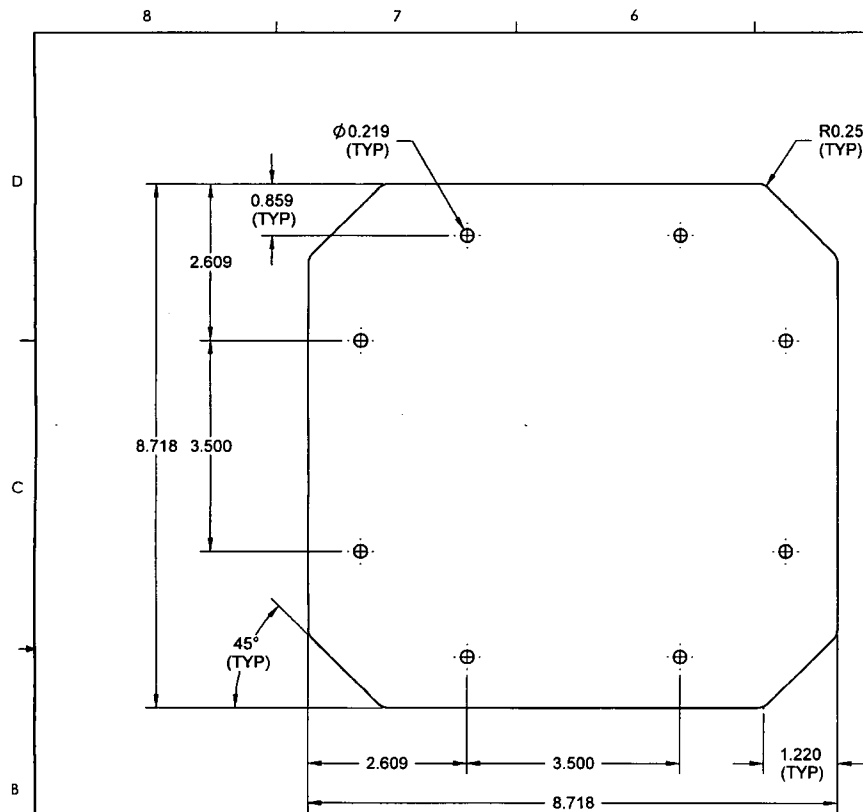
DESIGN		DART AEROSPACE LTD
DRAWN	JH	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3245 REV. B
MFG. APPR.	IS	SHEET 3 OF 7
APPROVED	NO	TITLE ACCESS PANEL ASSEMBLY SCALE 1:2
DE APPR.	CH	
DATE	07.10.02	

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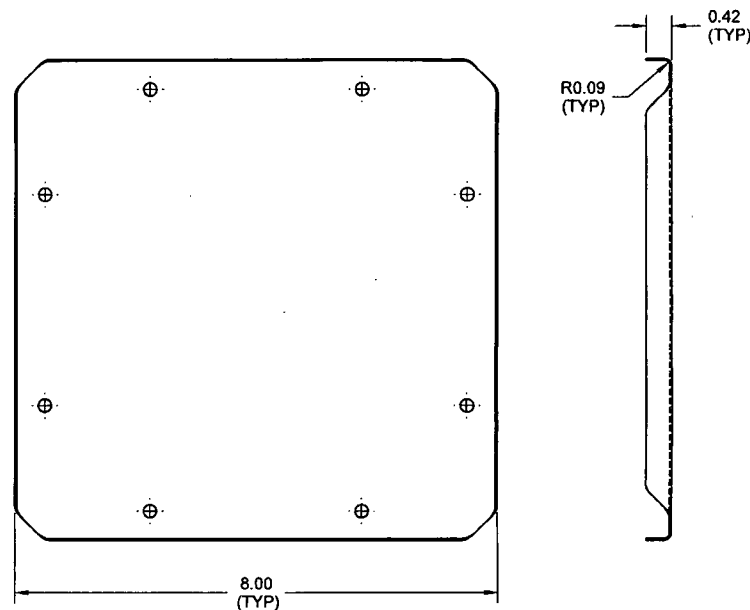
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(7/17/03)

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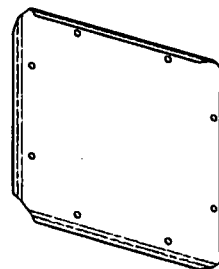
7 6 5 4 3 2 1



D3245-3F DOOR FLAT PATTERN



D3245-3 DOOR BENDING DETAIL



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	SS	D3245	SHEET 5 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL ASSEMBLY 1:2	
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07-10-02

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